

Date: Monday 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Split 2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 34477
Estimate Number : 12884
P.O. Number : *NIA*
This Issue : 9/10/2007 S.O. No. : *NA*
Prsht Rev. : NC
First Issue : *NA* Type : SMALL /MED FAB
Previous Run : 32648
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev:A New Issue 07.05.24 EC

Drawing Name : ARM
Part Number : D3560044
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : *EC*
Material : *NIA*
Due Date : 9/17/2007

Qty: *188* Um: *5* Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6B0500X05000

6061-T6 Bar 50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total: 16.3170 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: *M105646*

7th 07/09/20 (12)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks 15.500" long

7th 07/09/20 (12)

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *A* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

8th 07/09/22

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8th 07/09/22

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/23



Date: Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARH

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

334260 334478 = 5

PK 07.10.25

07.10.10 (5)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

PK 07.10.25 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/26 +5

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-26 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PK 07.10.26 (5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/10/26

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/26 (5X)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 07/10/26

PK 07.10.26 (5)

Date: \ Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

12/10/06

Job Completion



le 07/10/06

Handwritten text, likely bleed-through from the reverse side of the page. The text is arranged in several lines and is mostly illegible due to the quality of the scan and the nature of the bleed-through.

DART AEROSPACE LTD		Work Order:	34477
Description: Arm		Part Number:	D3560-4
Inspection Dwg: D3560	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

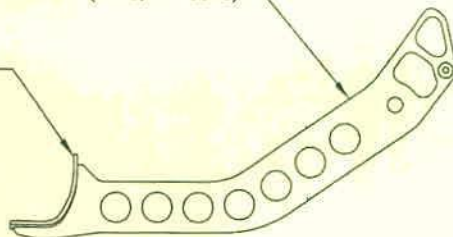
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.506	/			
Ø0.196	+0.005/-0.001	.197				
Ø1.000	+0.010/-0.001	1.003				
Ø0.900	+0.010/-0.001	.900				
0.500	+/-0.010	.494				
0.250	+/-0.010	.252				
0.275	+/-0.010	.277				
0.188	+/-0.010	.190				
2.000	+/-0.010	2.006				
1.750	+/-0.010	1.746				
1.702	+/-0.010	1.704				
Ø0.385 x 100°	+/-0.010 x 0.5°	.378				
0.250 Deep	+/-0.010	.248				

Measured by: <i>S.F.</i>	Audited by: <i>JF</i>	Prototype Approval:	N/A
Date: <i>07/07/22</i>	Date: <i>07/09/22</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM <i>JA</i>	<i>BE</i>

D3560-1 ARM (-041, SHOWN)
OR D3560-2 ARM (-042, OPPOSITE)

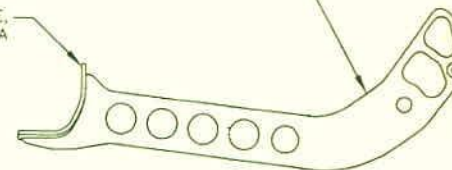
D3592-1 PLATE,
SEE DETAIL A



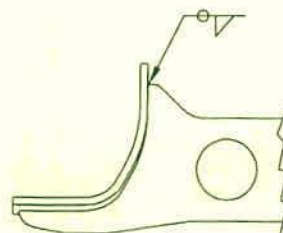
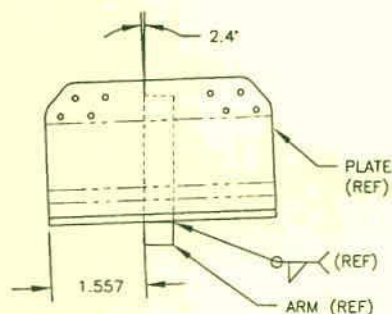
D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)

D3560-3 ARM (-043, SHOWN)
OR D3560-4 ARM (-044, OPPOSITE)

D3592-1 PLATE,
SEE DETAIL A



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

NO. 34477
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	th	APPROVED th
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE
		1:4

1870

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1870	1	2	3	4	5	6	7	8	9	10	11	12

1871

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1871	1	2	3	4	5	6	7	8	9	10	11	12

1872

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1872	1	2	3	4	5	6	7	8	9	10	11	12

1873

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1873	1	2	3	4	5	6	7	8	9	10	11	12

1874

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1874	1	2	3	4	5	6	7	8	9	10	11	12

1875

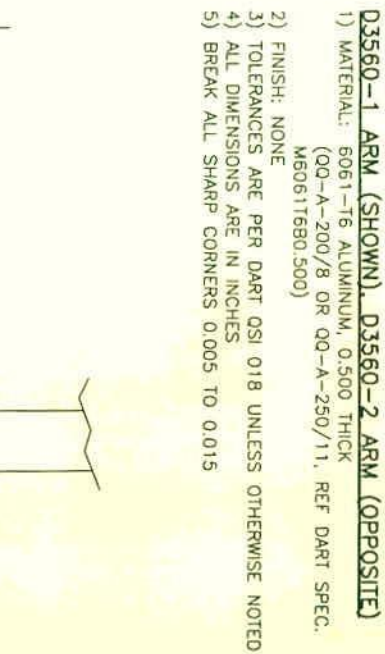
Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1875	1	2	3	4	5	6	7	8	9	10	11	12

1876

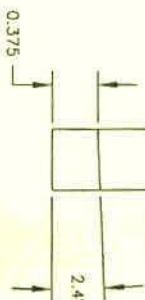
Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1876	1	2	3	4	5	6	7	8	9	10	11	12

1877

Month	Jan	Feb	Mar	Apr	May	June	July	Aug	Sept	Oct	Nov	Dec
1877	1	2	3	4	5	6	7	8	9	10	11	12



SCALE 1:1



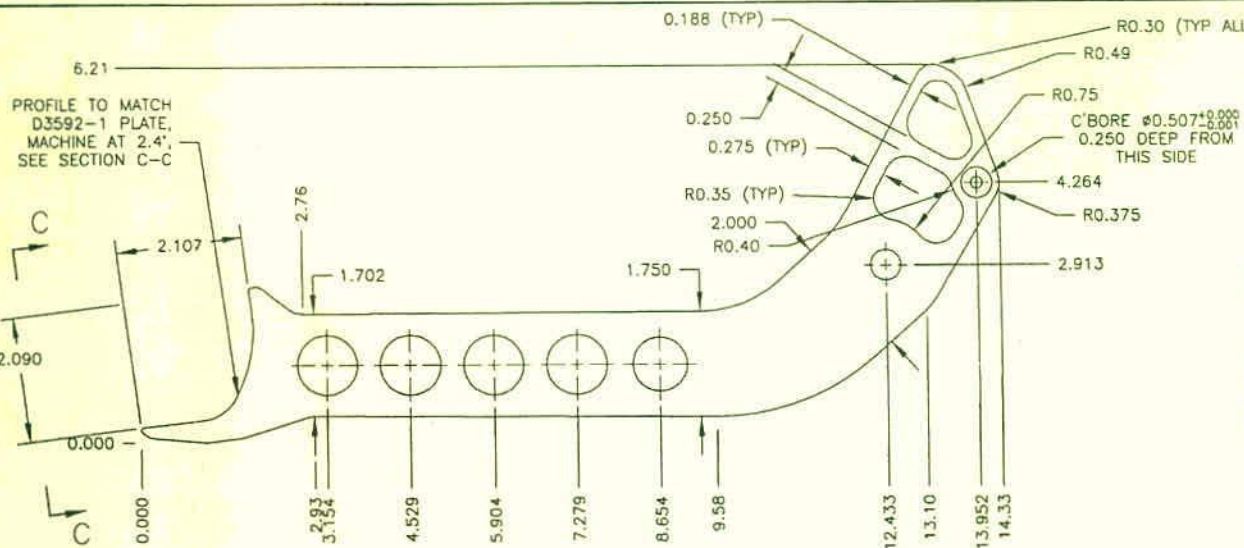
07.06.29-H

Ø0.196 (DRILL #9 REF)
C'SINK Ø0.385x100°

COPYRIGHT © 2006 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

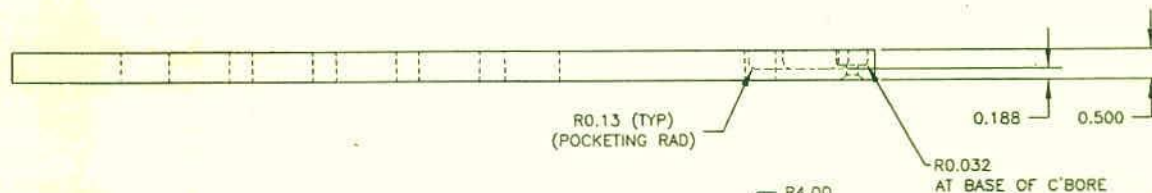
DESIGN	00	00	DART		DART AEROSPACE LTD. Hemel Hempstead, Hertfordshire, England
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
DATE	07.06.19			D3560	SHEET 2 OF 3
				TITLE	SCALE
				ARM WELDMENT	1:2

12

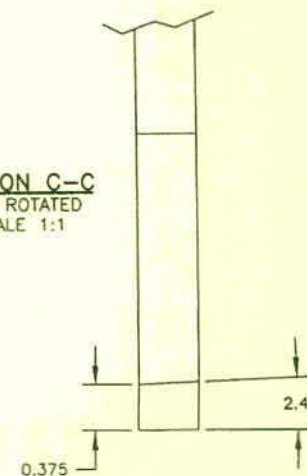


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

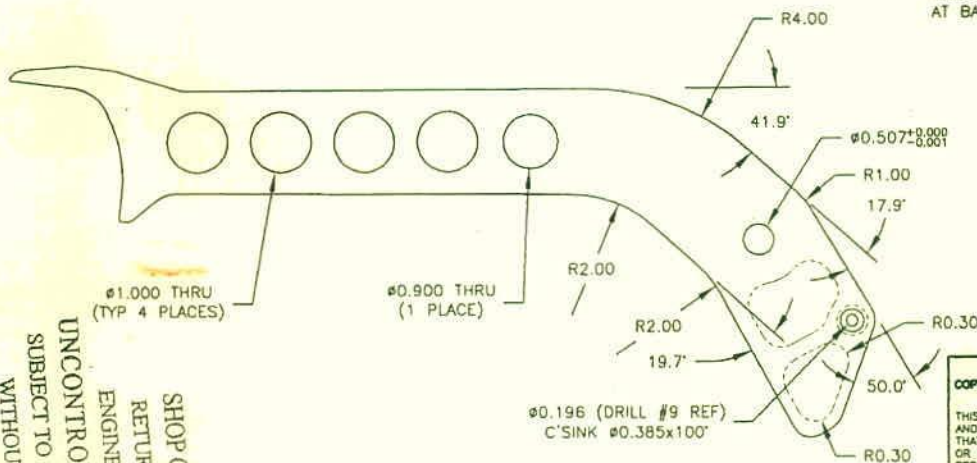
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.19



COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	92	DRAWN BY	92	DART	DART AEROSPACE LTD. WARRICKSLEY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3560	REV. C SHEET 3 OF 3
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE	1:2

NO. 344277

WORK ORDER

SUBJECT TO AMENDMENT WITHOUT NOTICE

UNCONTROLLED COPY

ENGINEERING

RETURN TO

SHOP COPY

